

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023723**Date Inspected:** 15-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yang ZPMC**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TA Yard OBG 13 / 14E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

TRIAL ASSEMBLY**Ultrasonic Testing (UT)**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no. 09140. The member(s) is/are identified as 13AE Floor Beam Rib Stiffener to Longitudinal Diaphragm, Rib Stiffener to Floor Beam, and Deck Plate Rib Stiffener to Floor Beam. The weld designations reviewed are as follows

SEG3007B-257, 262, 267, 272, 277, 282, SEG3007F-043, SEG3007H-040, SEG3007K-045
SEG3007S-032, 034, 038, 044, 189, SEG3007R-163, 127, 131, SEG3007Q-013, 018, 023, 025

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 09138. The member(s) is/are identified as Lift 13AE Edge Beam to Floor Beam. The weld designations reviewed are as follows

SEG3007R-150, 152, 178, 158, 159, 154, 155, SEG3007S-176, 178, 211, 184, 185, 180, 181

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This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on lift 13BE, SEG3009B Edge Beam to Floor Beam weld number(s) 401, 107. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-T-2233-ESAB.

FCAW welding of complete joint penetration weld joint(s) located on lift 13BE, SEG3009B Side Plate Rib Stiffener to Floor Beam weld number(s) 117, 121, 125, 129, 133, 137, 093, 097, 101, 105, 109, 113. Welder is identified as welder no. 050977. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-345-FCAW-3G (3F)-ESAB-Repair and B-WR20996.

FCAW welding of fillet weld joint(s) located on lift 13BE, SEG3009B Edge Beam to Bottom Plate weld number(s) 105 and 200. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Wang Xu appeared to comply with applicable WPS(s) WPS-B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond, Robert

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer